

Date: Tuesday, 4/17/2007 3:09:02 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	CYCLIC GRIP/STICK OPTION C		
Job Number	31939		Part Number	P107		
Estimate Number	12829		Drawing Number	GA122 REV A		
P.O. Number	N/A		Project Number	N/A		
This Issue	4/17/2007	S.O. No. <i>N/A</i>	Drawing Revision	A		
Prsht Rev.	NC	Type	Material	<i>N/A</i>		
First Issue	<i>N/A</i>		Due Date	4/24/2007	Qty:	1 Um: Each
Previous Run	:					
Written By	:					
Checked & Approved By	:					
Comment	Est Rev:A New Issue 07-04-16 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP P107			
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1 Pick Packing Kit			
3.0	332A27 2114 21 ✓	BOOT	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) BOOT Batch: <u>M103779 - X</u>			
4.0	3410 14	Split Ring	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Split Ring Batch: <u>M103779 - X</u>			
5.0	341A27 1368 20W	BOOT	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) BOOT Batch: <u>M1037 79 - T S. Boz/04/18</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 31939

Part Number: P107

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 350A27 1185 00

PEDAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PEDAL

Batch: M103882 - X

7.0 350A27 1185 01

PEDAL, DIRECTIONAL CONTROL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PEDAL, DIRECTIONAL CONTROL

Batch: M103779 - X

8.0 350A27 1328 01

PLATE, BOOT MOUNT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PLATE, BOOT MOUNT

Batch: M103779 - X

9.0 350A27 1340 20

COPILOT GRIP ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

COPILOT GRIP ASSEMBLY

Batch: M103779 - X

10.0 ~ 350A27 1375 00 97

COVER, PITCH STICK



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

COVER, PITCH STICK

Batch: M103779 - X

11.0 350A27 1375 20

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

Batch: M103779 - X

=>

12.0 350A27 1376 20

Bushing, Tapped



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bushing, Tapped

Batch: M103779 - X

E/S 04/04/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: CYCLIC GRIP/STICK OPTION C

Job Number: 31939

Part Number: P107

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 350A27 1525 0101 COLLERETTE FLANGE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

COLLERETTE FLANGE

Batch: M103779-



14.0 350A27 1528 0101 SHIM



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SHIM

Batch: M103779-



15.0 A0023C06R35NW PIN, LOCKING



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PIN, LOCKING

Batch: M103779-



16.0 ASNA0033 045 Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clamp

Batch: M103779-



17.0 G10201 Collective Stick



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Collective Stick

Batch: B31945-



18.0 G10202 CYCLIC STICK



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CYCLIC STICK

Batch: B31943



19.0 G10204 Replacement Cyclic Grip



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Replacement Cyclic Grip

Batch: M104131-



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 31939

Part Number: P107

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 MS3116E20 41P Connector, 41 pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Connector, 41 pin



Batch: M10377S -

21.0 GA10205 Co-pilot Ext.



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Co-pilot Ext.

Batch: B 31944 -

X 07/04/18

22.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

11 07-04-18 C 07/04/18 (1)

23.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP P107

Location: N/A

PPP Rev: Draft

u 07/04/18

24.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1) 07/04/18

Job Completion



u 07/04/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

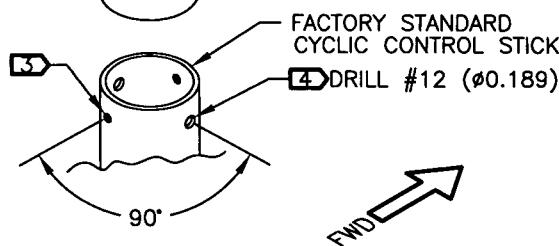
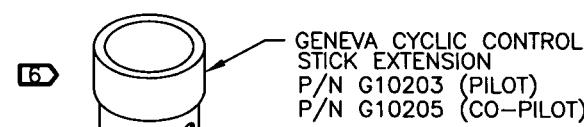
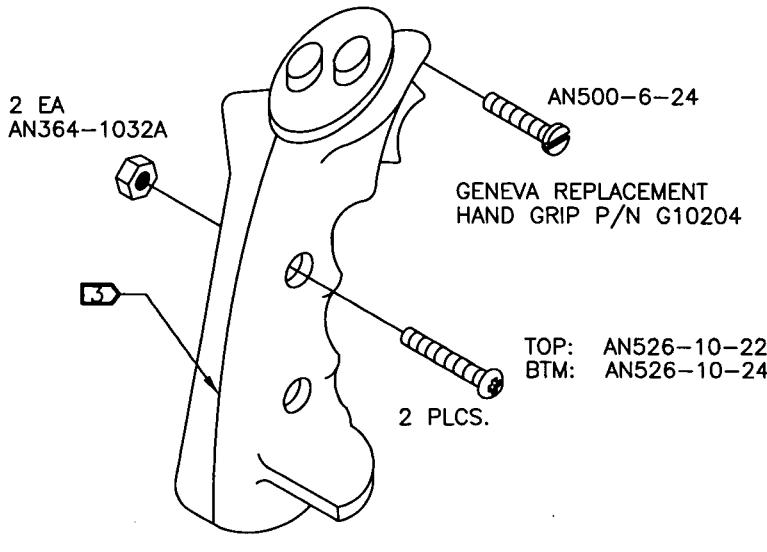
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

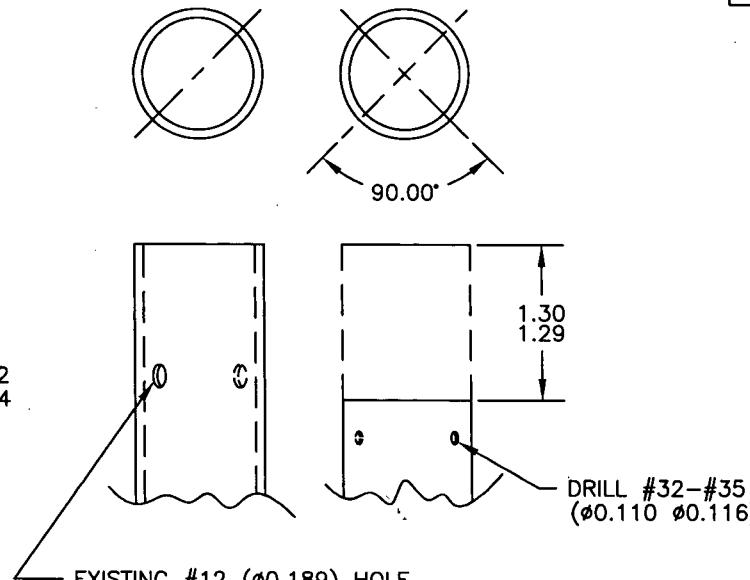
NOTE: Date & initial all entries

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 WORK ORDER
 NO. 21939

REVISIONS		
REV	DESCRIPTION	APVR/DATE
A	REDRAWN; COMBINED SHEETS 1 & 2	5/30/03 CLB



OPTIONS A & D: ALTERATION OF FACTORY STANDARD CYCLIC CONTROL STICK



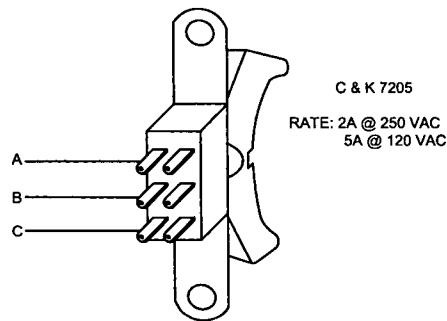
5 WHEN INSTALLING THE FACTORY STANDARD HAND GRIPS ONTO A GENEVA REPLACEMENT CYCLIC STICK, IT IS NECESSARY TO SHORTEN THE CONTROL STICK BY 1.3". BEFORE SHORTENING THE STICK, MARK THE LOCATION OF THE 0.11" DIA. HOLE USING THE EXISTING #12 HOLE AS A REFERENCE. THIS IS IMPORTANT TO GET THE PROPER ORIENTATION OF THE HAND GRIP. CLEAN AND DEBURR AFTER CUTTING DRILLING.

6 EXTENSION REQUIRED WHEN INSTALLING THE GENEVA HAND GRIP ONTO FACTORY STANDARD CYCLIC CONTROL STICKS. NOTE: DIFFERENT LENGTHS REQUIRED FOR PILOT AND CO-PILOT SIDES.

NOTES:																					
OPTIONAL: TEXT MAY BE ENGRAVED, STAMPED OR PRINTED ON PART AS DESIRED																					
2. FOR CLARIFICATION, SEE GA122-1, INSTALLATION INSTRUCTIONS. OPTIONS INCLUDE:																					
A. INSTALL P/N G10204 HAND GRIP ONTO FACTORY STANDARD CYCLIC CONTROL STICK.																					
B. INSTALL GENEVA CO-PILOT CONTROLS WITH FACTORY STANDARD CYCLIC CONTROL HAND GRIP.																					
C. INSTALL GENEVA CO-PILOT CONTROLS WITH GENEVA CYCLIC CONTROL HAND GRIP.																					
D. INSTALL GENEVA CO-PILOT CONTROL WITH GENEVA CYCLIC CONTROL HAND GRIP AND INSTALL GENEVA CYCLIC CONTROL HAND GRIP ONTO FACTORY STANDARD CYCLIC STICK ON PILOT SIDE.																					
3 WHEN INSTALLING OPTIONS A OR D (P/N G10204 ONTO FACTORY CYCLIC STICK), ALIGN THE SEAM (3) OF THE HAND GRIP WITH THE EXISTING MOUNTING HOLE (3) AND MATCH DRILL CYCLIC STICK, EXTENSION (4) TO LOWER MOUNTING HOLE ON HAND GRIP.																					
<table border="1"> <tr> <td>BREAK SHARP EDGES</td> <td>DESIGNED</td> <td>CLB</td> <td>DATE</td> </tr> <tr> <td>125</td> <td>DRAWN</td> <td>DATE</td> <td>5/30/03</td> </tr> <tr> <td>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</td> <td>CHECKED</td> <td>DATE</td> <td></td> </tr> <tr> <td>TOLERANCES ARE: FRACTIONS DECIMAL ANGLES ±1/16" ±.005" ±2° XX ±.000 ±.010</td> <td>APPROVED</td> <td>DATE</td> <td></td> </tr> <tr> <td>THIS DOCUMENT INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION AND SHALL NOT BE USED OR DUPLICATED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION, INC.</td> <td>GLH</td> <td>DATE</td> <td>5/30/03</td> </tr> </table>		BREAK SHARP EDGES	DESIGNED	CLB	DATE	125	DRAWN	DATE	5/30/03	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	CHECKED	DATE		TOLERANCES ARE: FRACTIONS DECIMAL ANGLES ±1/16" ±.005" ±2° XX ±.000 ±.010	APPROVED	DATE		THIS DOCUMENT INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION AND SHALL NOT BE USED OR DUPLICATED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION, INC.	GLH	DATE	5/30/03
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Geneva Aviation www.GenevaAviation.com																					
Drawing Number GA122-10 REV A																					
Pro No: GA122 SIZE B Scale: 1:1 Sheet 1 of 1																					

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REVISIONS		
REV	DESCRIPTION	APVR/DATE
A	REDRAWN ON CAD; ADDED NOTES 4, 5 & 6 ; ADDED WIRING CONNECTION TABLE	5/30/03 CLB



CONNECTOR
PIN
LOCATION

AEC WIRE NUMBERS	GENEVA NUMBERS	LARGE CONNECTOR PIN LOC'S	
23	A	Z	XMIT
24 & 18	B	D	GND
17	C	C	ICS
	D	A	SPARE
	E	B	SPARE

NOTES:

1. SOLDER CONNECTIONS AND JUMPER ACROSS.
2. INSTALL WIRING PER AC43:13.
3. SEE GA122-1, INSTALLATION INSTRUCTIONS.
4. SMALL CONNECTOR: P/N SOURIAU 851 06RC
1419P 50.
LARGE CONNECTOR: P/N SOCAPEX SPT 06E
20-41P 90 38 ; or
MS3116E20-41P.
5. SPARES TO BE CAPPED OFF AND TIED BACK.
6. ALL WIRE TO BE #20 AWG
MIL-W-22759/16-20 OR EQUIV.

BREAK SHARP EDGES UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	125	DESIGNED	CLB	DATE	5/30/03
		DRAWN		DATE	
TOLERANCES ARE: FRACTIONS X .005 ANGLES .010 X .005 2° .005 X .005 2° .010 X .010		CHECKED		DATE	
		APPROVED	GLH	DATE	5/30/03
<small>THIS DOCUMENT INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION, INC. IT IS NOT TO BE COPIED OR DUPLICATED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION, INC.</small>					
Drawing Number		GA122-70	REV	A	
Pro No:		GA122	SIZE	B	Sheet 1 of 1